

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : WEARSHOE
Job Number : 41634
Estimate Number : 10618
P.O. Number :
This Issue : 27/08/2008 S.O. No. :
Prsht Rev. : NC Part Number : D265637
First Issue : / / Type : SMALL /MED FAB Drawing Number : D2656 REV D
Previous Run : 34510 Project Number : N/A
Material :
Due Date : 05/09/2008 Qty: 10 Um: Each
Written By :
Checked & Approved By : JUL 08.8.26
Comment : Est Rev: D 02.10.25 Re-format KJ
Est Rev: E 06-06-12 Now on Waterjet JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M1010S20GA 1010/1025 SHEET



7.5



Comment: Qty.: 0.5650 sf(s)/Unit Total : 5.6501 sf(s)
1010/1025 .040" SHEET
(M1010S20GA)
Batch: 107906 HB 8-9-2

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET
1-Cut as per Dwg D2656
Dwg Rev: B
Prog Rev: B

HB 8-9-2

(13)

2-Deburr if necessary

HB 8-9-2

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



HB 8-9-2



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

5 08/09/08 (P13)

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Deburr if necessary.

u/a Done at step #2.2
8/2/9/3

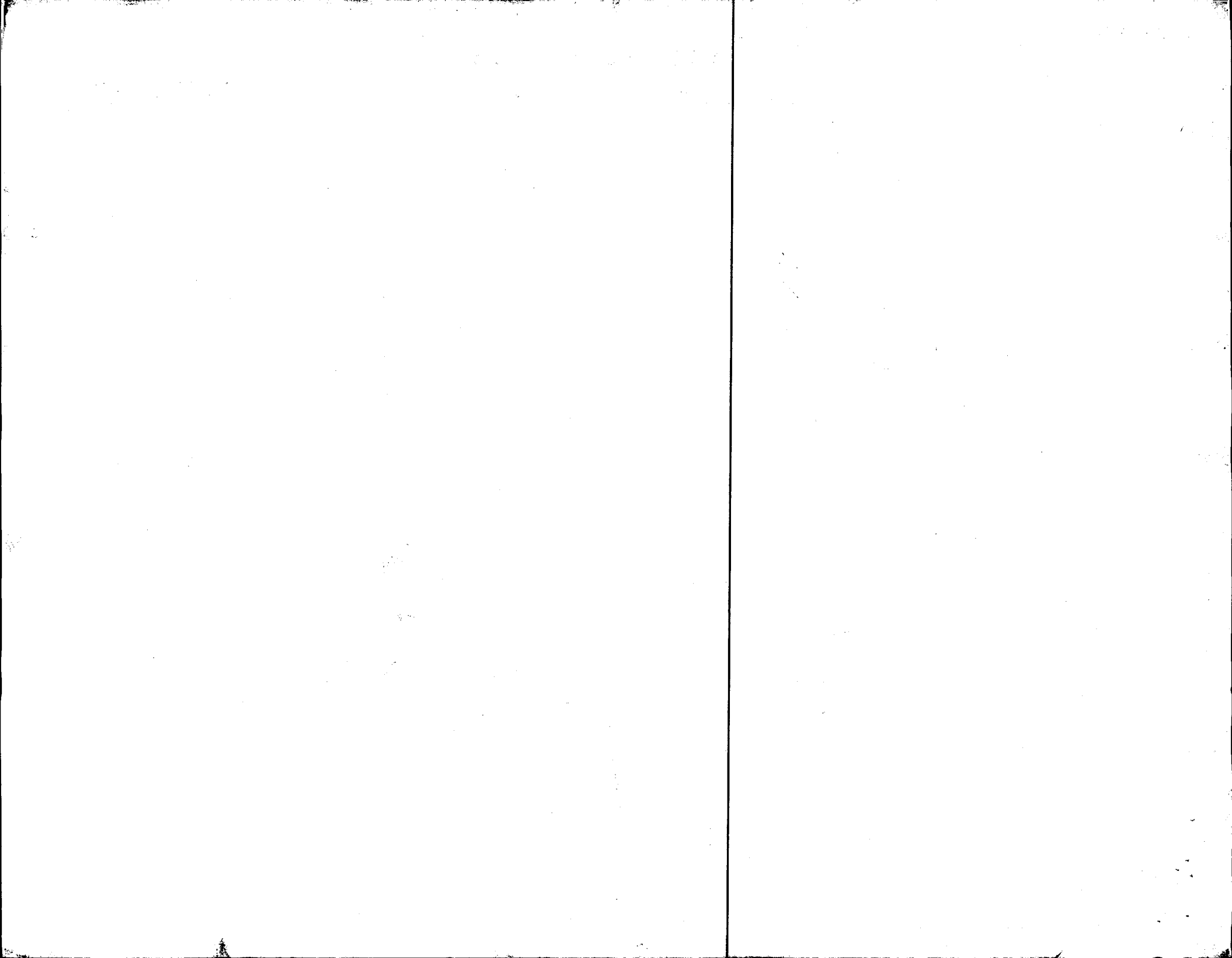
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Date: Wednesday, 27/08/2008 11:37:30 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 41634

Part Number: D265637

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

1-Form on Brake as per Dwg D2656 using Jigs DT8261 and DT8326.

2- Identify as D2656-37

SB 08/09/08

(13)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/08/08 (13)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

10:25

OVEN TEMPERATURE:

320°

FINISH TIME:

10:55

FL 08/09/08

(13)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-J 08/09/08

(13X)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

F-P 20

M-J

08/09/08

(13X)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE



08/09/09

Job Completion

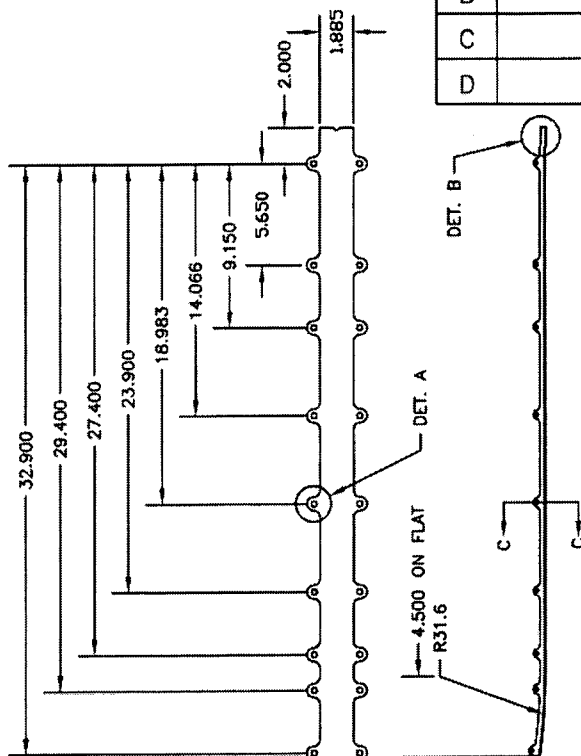


MF 08-09-08

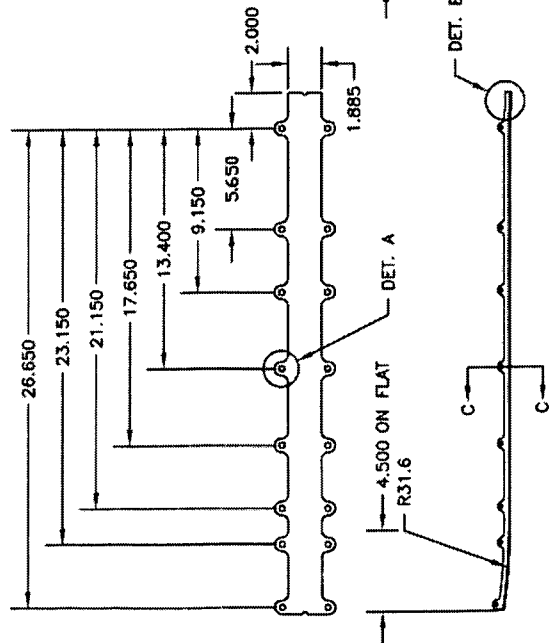


DESIGN DS		DRAWN BY CP		DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED 		APPROVED 		DRAWING NO. D2656	REV. D SHEET 1 OF 4
DATE 05.08.17				TITLE WEARSHOE	SCALE 1:10
A	97:03:25		NEW ISSUE		
B	97:06:02		CHANGED TABS		
C	97:06:26		R31.6 WAS R19.5		
D	05.08.17		ENLARGE ALL HOLES TO IMPROVE FIT		

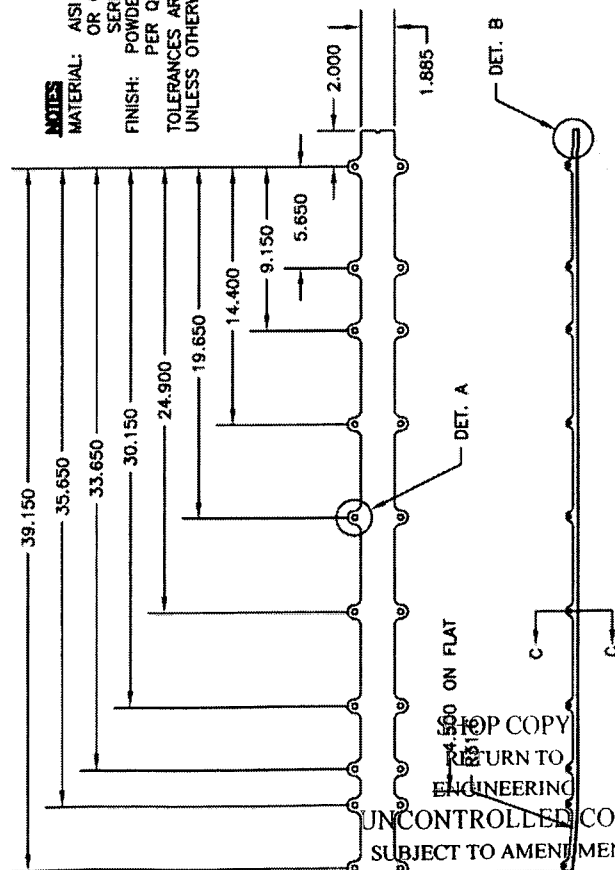
D2656-13



D2656-11



D2656-15



NOTES: AISI 1010-1025 OR ASTM A36/A366/A1008
OR CSA G40-21, 38W/44W/50W/60W/70W
SERIES STEEL 20 GAUGE (0.040 THICK)
FINISH: POWDER COAT GREY SANDTEX (4.3.5.6)
PER QSI 005 4.3
TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED

RELEASED
05-09-02

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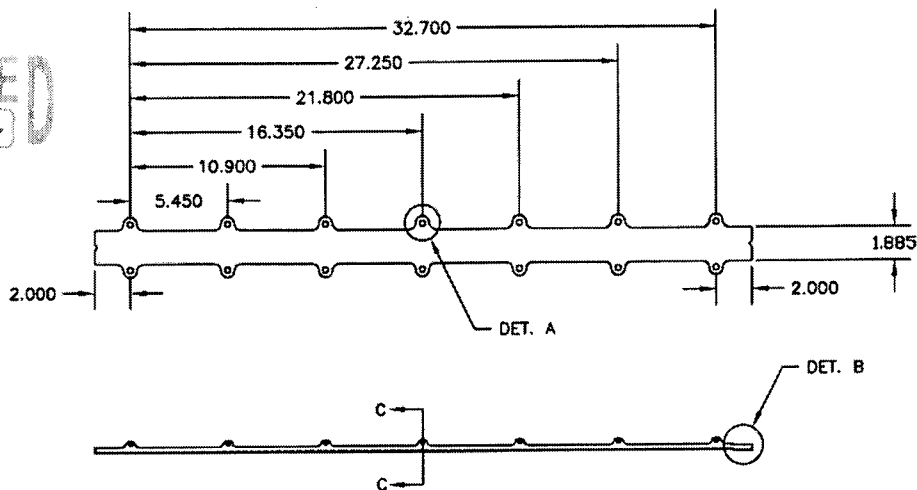
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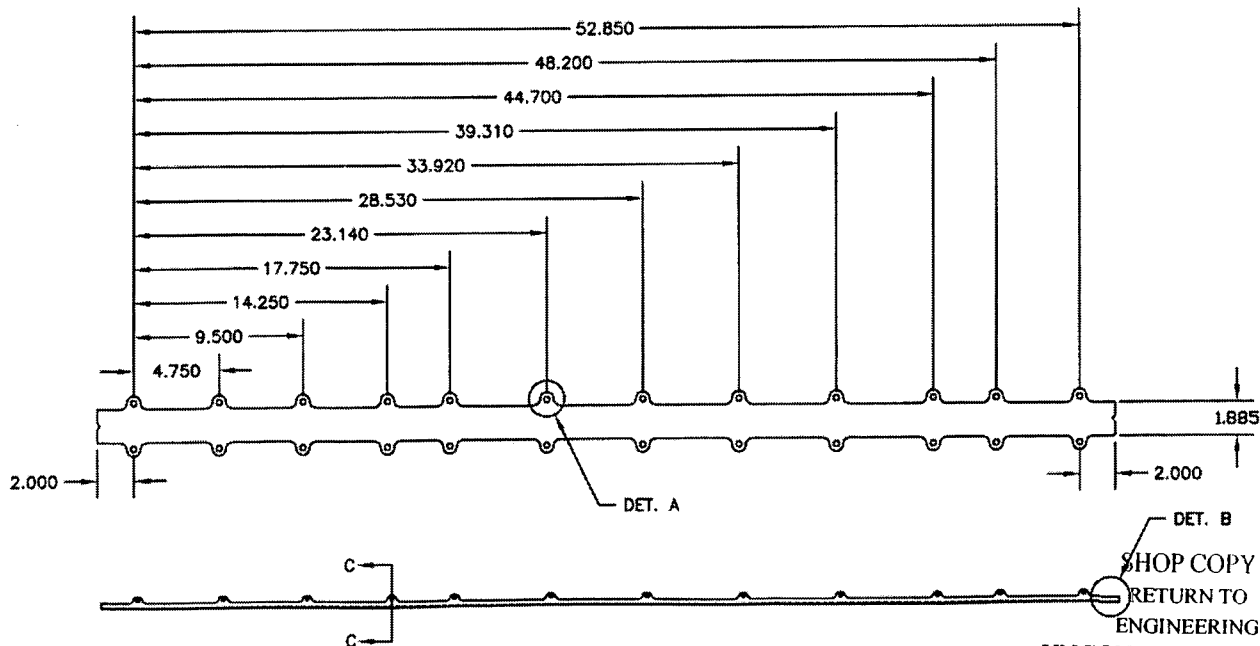
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DATE 05.08.17	TITLE WEARSHOE		SCALE 1:10

RELEASED
05.09.00

D2656-21



D2656-23



NOTES

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W
SERIES STEEL, 20 GAUGE (0.040 THICK)
FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
TOLERANCES ARE PER DART QSI 018
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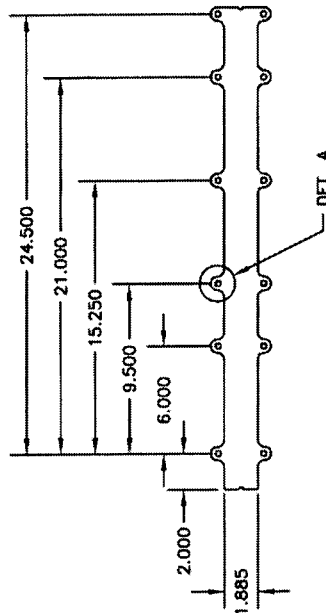
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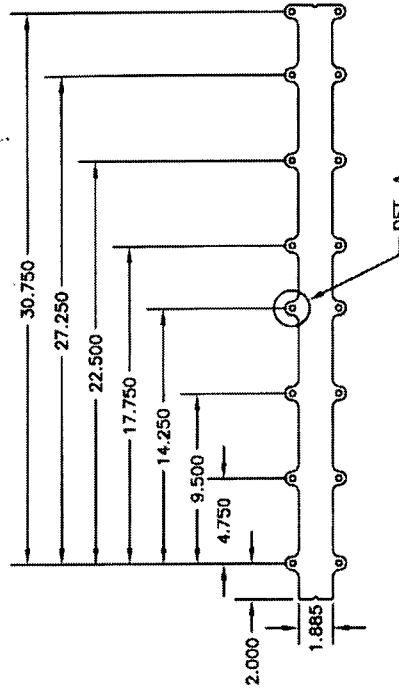


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DATE 05.08.17	TITLE WEARSHOE	SCALE 1:10	

D2656-33

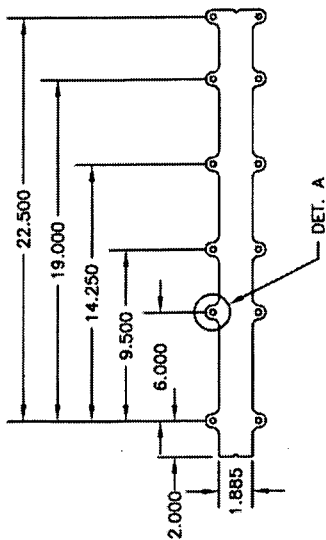


D2656-37

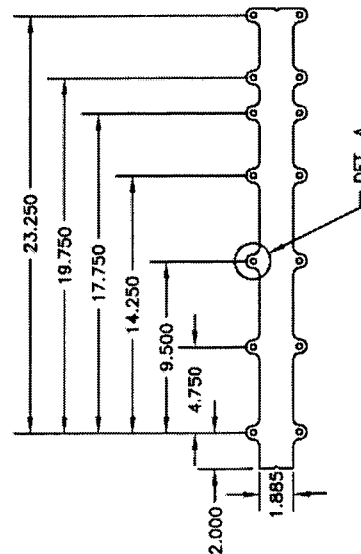


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05.07.00 #

D2656-31



D2656-35



SHO
R
ENGINEER
MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W
FINISH: SERIES STEEL, 20 GAUGE (0.040 THICK)
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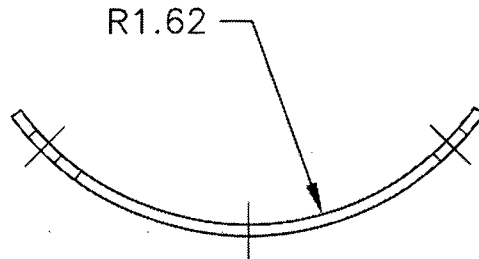
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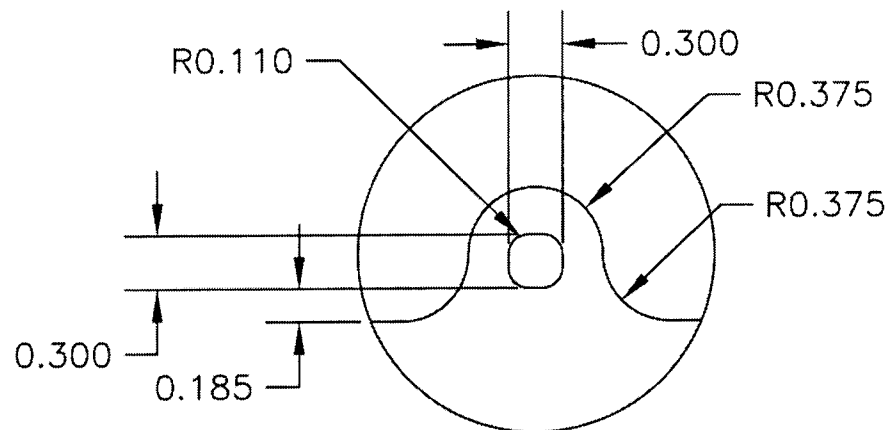
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				D2656	SHEET 4 OF 4
DATE	05.08.17	TITLE	WEARSHOE	SCALE	1:10

SECTION C-C

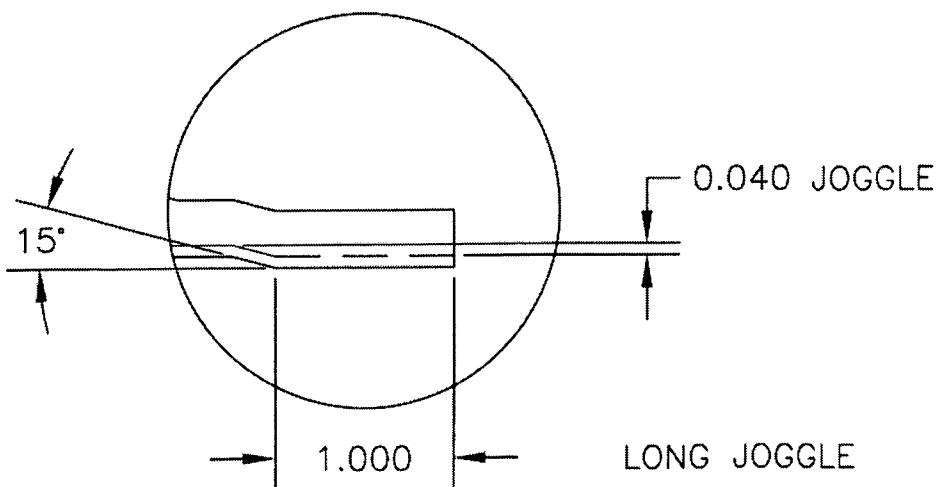


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DETAIL A



DETAIL B



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